

Work Order ID 76299

76299

Page 1

November-08-11 1:33:08 PM

Item ID: D4149-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Assembly, Aft

Start Date: 08/11/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 22/11/2011 Req'd Qty: 3.00 ***3*** Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	C

100		0.00
100		
Small Fab	Memo	0.00
Small Fab	1- Assemble as per dwg	

Handwritten: 11/11/15 (3)

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

Handwritten: Dulwico

Handwritten: (x3)

120	Identify as per dwg & Stock Location <u>ST468</u>	0.00
120		
Packaging	Memo	0.00
Packaging		

Handwritten: (3x) 11-11-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76299***76299***

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Item Name: Crosstube Lug Assembly, Aft

Start Date: 08/11/2011 Start Qty: 3.00 ***3***

Cust Item ID:


Required Date: 22/11/2011 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

11/11/21 

R1111-18
(3)

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 76299

76299

Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 08/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	727.0000	4	6			
MS21043-3									**				
Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				72					
					103691			72					
				ST301				655					
					118077			1					
					118614			477					
					118686			177					
MS21043-4		Purchased	No			100	Each	1,557.000	1	9			
MS21043-4									**				
Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				40					
					104603			40					
				ST301				1517					
					117793			22					
					118686			500					
					119309			495					
					119546			500					

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Page 2

Work Order ID: 76299

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 08/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

D3910-1 Manufactured No

100 Each 28.0000 1 3

D3910-1

Crosstube Lug

**

Location

Loc Qty

Loc Code

ENG

2

70160

2

st507

26

73527

26

D4091-1 Manufactured No

100 Each 10.0000 1 3

D4091-1

Mounting Lug

**

Location

Loc Qty

Loc Code

ST460

10

69605

10

D4149-1 Manufactured No

100 Each 8.0000 2 6

D4149-1

Crosstube Lug Plate, Aft

**

Location

Loc Qty

Loc Code

ST133

8

69604

8

D4149-3 Manufactured No

100 Each 5.0000 1 3

D4149-3

Spacer

**

Location

Loc Qty

Loc Code

ST133

5

68870

5

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W/O:		WORK ORDER CHANGES					
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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 08/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

D4149-5 Manufactured No

100 Each 13.0000

1 3

D4149-5

Eyebolt Stud

**

Location

Loc Qty

Loc Code

ST133

13

68871

3

73548

10

AN3C12A Purchased No

100 Each 108.0000

2 6

AN3C12A

Bolts

**

Location

Loc Qty

Loc Code

ST351

108

117514

4

118112

5

118422

17

118451

22

118838

10

119510

50

AN4C13A Purchased No

100 Each 49.0000

3 9

AN4C13A

BOLT

**

Location

Loc Qty

Loc Code

ST357

49

118838

49

MS20615-4M18 Purchased No

100 Each 497.0000

3 9

MS20615-4M18

Rivet

**

Location

Loc Qty

Loc Code

ST323

497

118077

312

118543

185

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 08/11/2011

Required Date: 22/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0332R

Purchased

No

100

Each

2,352.000

4

12

NAS1149C.0332R

Washer

**

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

2345

116304

55

117460

18

117887

169

118078

2

118179

78

118354

1283

119124

740

NAS1149C0432R

Purchased

No

100

Each

4,412.000

6

18

NAS1149C.0432R

Washer

**

Location

Loc Qty

Loc Code

ST297

4412

117291

3412

119124

1000

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

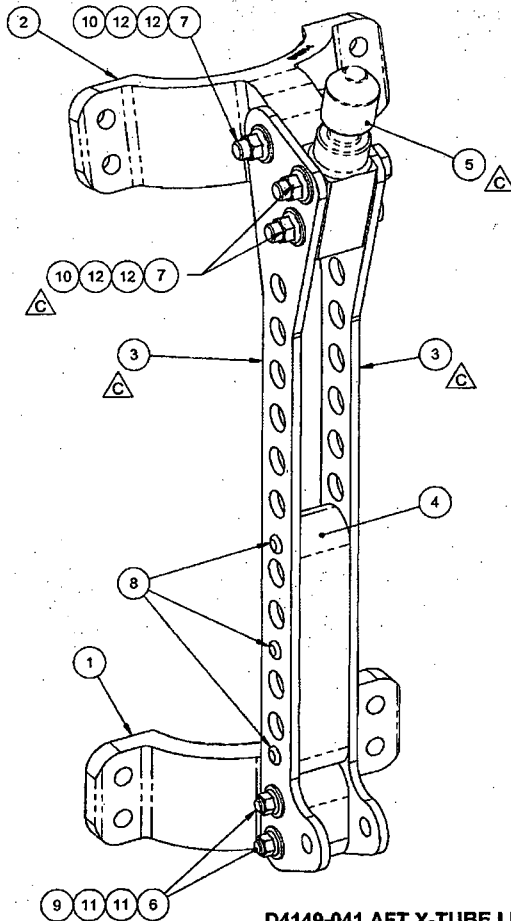
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76299 M.C.J.

11/11/08

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4149** REV. C
SHEET 1 OF 5
TITLE **AFT X-TUBE LUG ASSY** SCALE NTS

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RELEASED
2011-02-20

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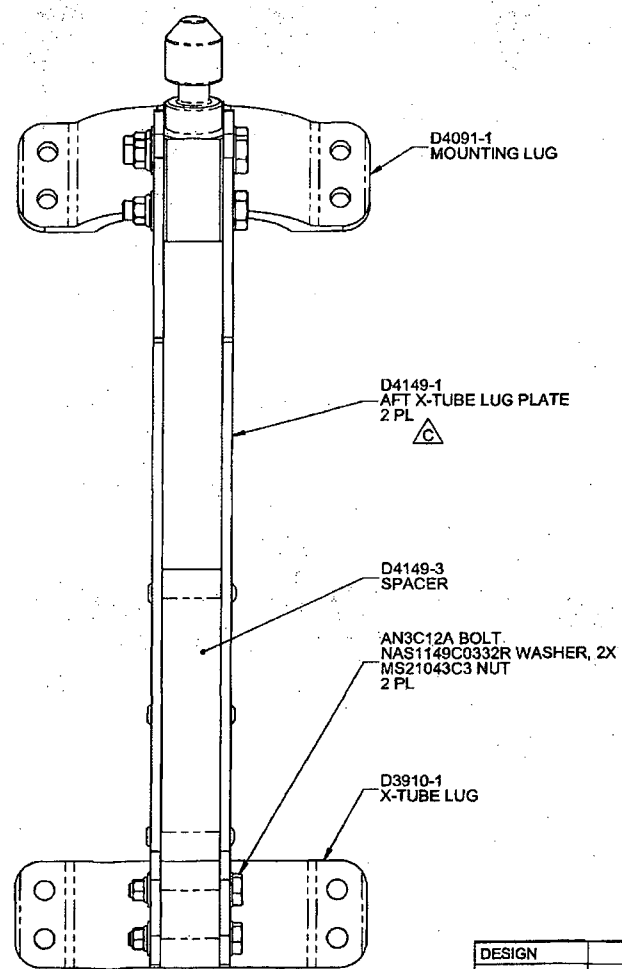
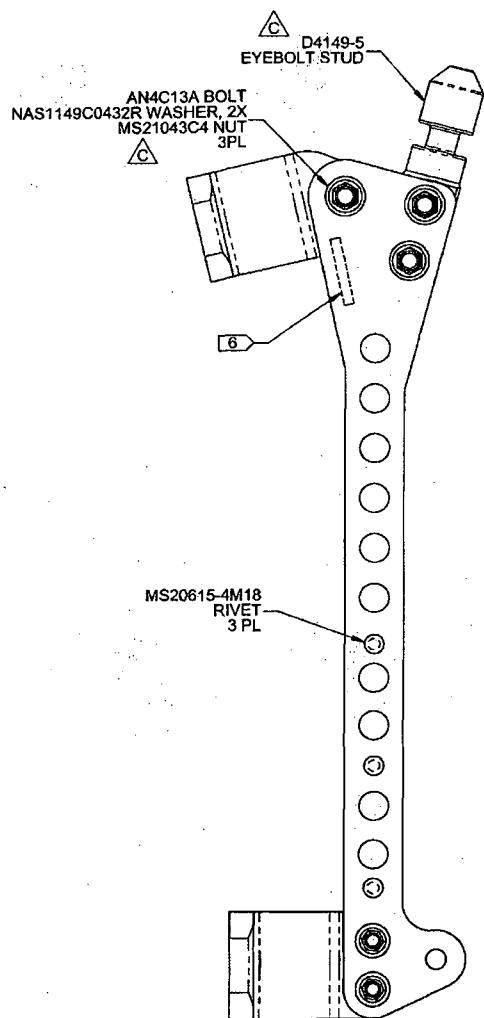
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76299



D4149-041 AFT X-TUBE LUG ASSY

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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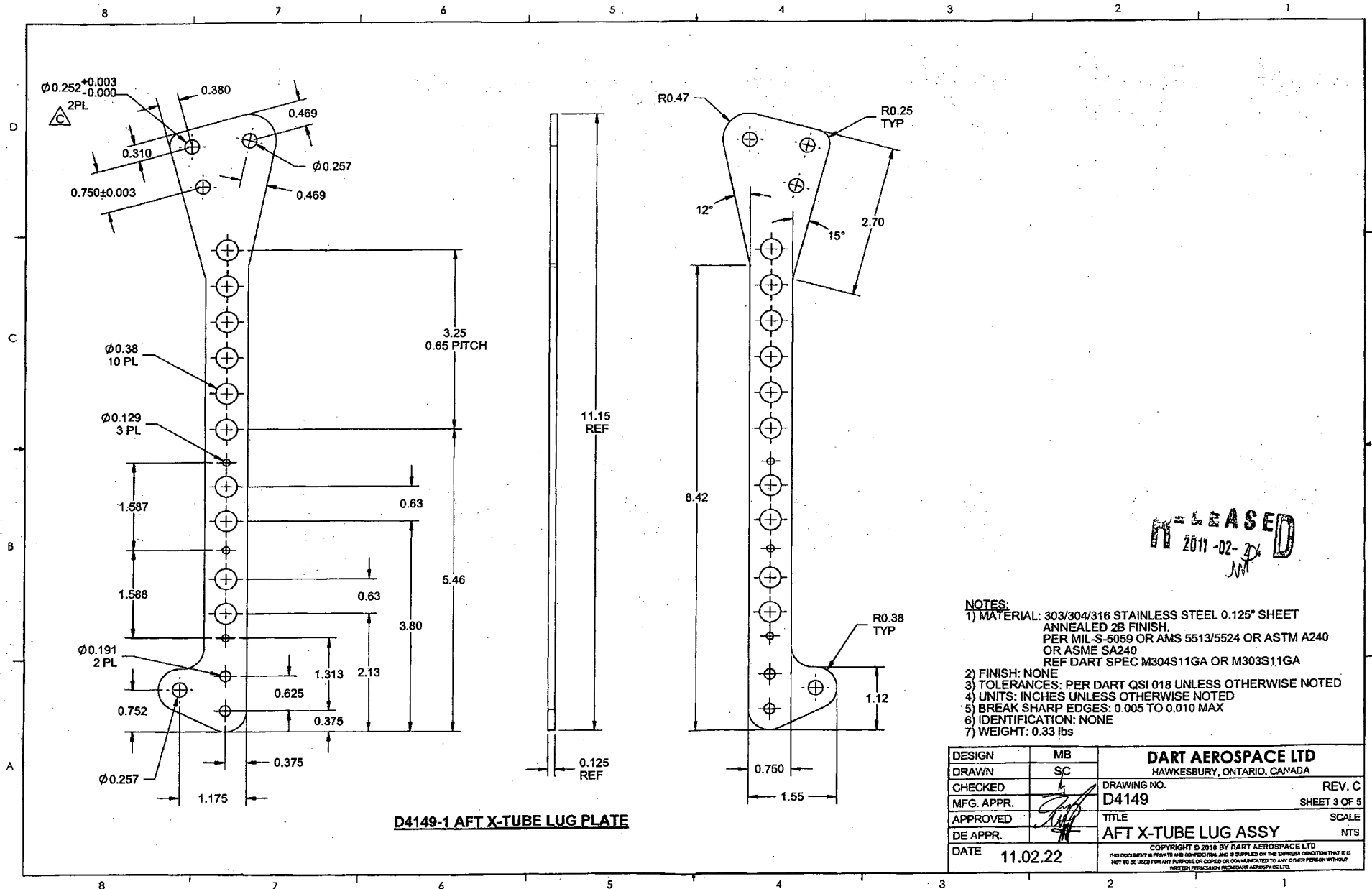
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

76299



RELEASED
2011-02-24

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 3 OF 5
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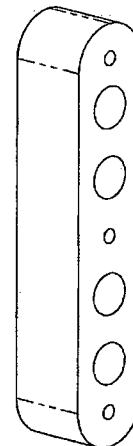
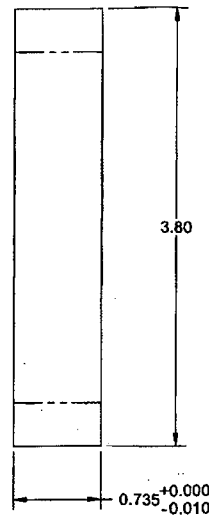
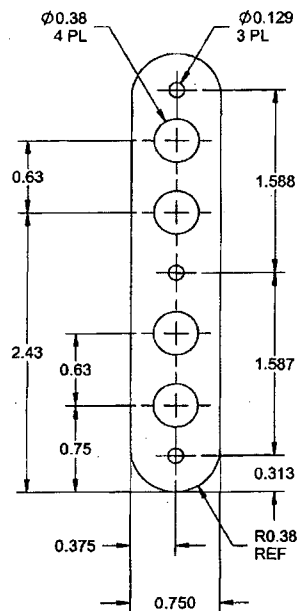
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NOTE: Date & initial all entries

76299





D4149-3 SPACER

RELEASED
2011-02-22

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
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MFG. APPR.		D4149	SHEET 4 OF 5
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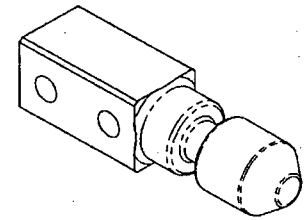
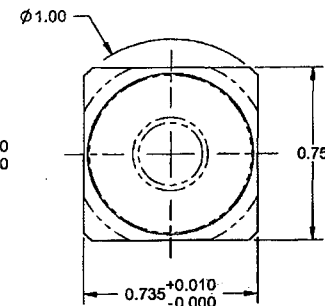
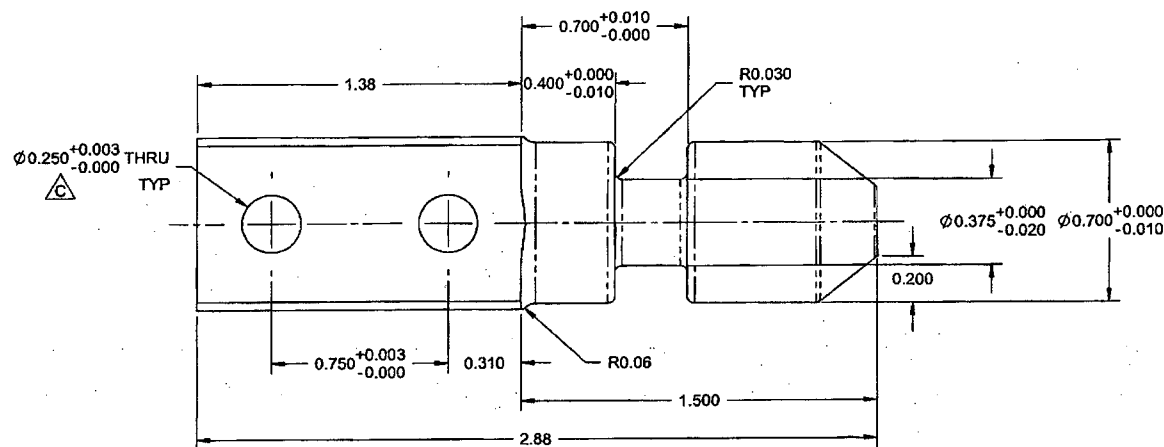
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NOTE: Date & initial all entries

76299



D4149-5 EYEBOLT STUD

RELEASED
2011-02-26

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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